



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D5522-1

Job Sheet 199877



Part No: D5522-1

Job Qty: 4 pcs

Part Name: Oil Drain Valve Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/3/19

Job Tracking No:

Due Date: 9/20/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: D5522 REV.C IPP REV:A 17.05.29 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.17 MODIFY PROCESS TO MATCH INTUITIVE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	9/20/19	9/20/19	0.00	0.40	Bandsaw - 1		19-09-03
110	HAAS 5 Axis - B4B	4 pcs	9/20/19	9/20/19	0.75	2.00	HAAS - 5 - B4B		19-09-08
120	QC 2	4 pcs	9/20/19	9/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		19-09-08
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



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Container No: S211038



Part: D5522-1

Job No: 199877

Serial No/Batch: S211038

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/03/19

				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	4 pcs	9/20/19	0.00 0.00	QC 8 - 12	DAS 14 9-89
				QC 8 - 14	219/09/10
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Small Fab - 2 - B4B	4 pcs	9/20/19	0.00 0.40	Small Fab - 1 - B4B	DAS 58 SEP 13 2019 9-89
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
150 QC 5	4 pcs	9/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS DEC 09 2019 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Packaging 3-1 - Stock - B4B	4 pcs	9/20/19	0.00 0.00	Packaging 3 - 1 - B4B	

				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	4 pcs	9/20/19	0.00 0.00	QC 21 - SA - 21	DAS 58 9-29 DEC 10 2019
				QC 21 - SA - 70	21 9-29 DEC 10 2019
				QC 21 - SA - 53	
Part Op 100 - Bandsaw - Cut blanks at 3.63" Descriptions: 110 - HAAS CNC vertical machine #5 - 1-Machine D5522-1 as per Folio FB540 and Dwg D5522. 2-Deburr 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Small Fab - USE ULTRA SONIC TO CLEAN D5522-1 PART MUST BE DRY INSTALL PLASTIC PUSH-ON CAPS 150 - QC5- Inspect part completeness to step on W/O ***BEFORE PUTTING THE CAPS VERIFY IF THE PART IS CLEAN INSIDE*** 160 - Identify as per dwg & Stock Location: ST 166 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303B1.500X3.500	303 Bar 1.500" X 3.500"	1.2000 ft (.3 ea)	100-Bandsaw - 1	S154 894	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M303B1.500X3.500	1	7	0	
Part Specifications					
Specifications could not be found.					

DART AEROSPACE LTD		Work Order: 199877
Description: OPI Drain valve MOUNT		Part Number: D5522-1
Inspection Dwg: D5522 Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	+/- .030	3.451	✓		SLIO	Vern
2.35	+/- .030	2.350	✓			
3.35	+/- .030	3.346	✓			
2.00	+/- .030	2.000	✓			
1.25	+/- .030	1.248	✓			
R.63	+/- .030	.630	✓		Rad gauge	
.94	+/- .030	.946	✓		SLIO	
.80	+/- .030	.800	✓		"	
.80	+/- .030	.800	✓		"	
R.13	+/- .030	.130	✓		Rad gauge	
2.13	+/- .030	2.130	✓		SLIO	
R.41	+/- .030	.410	✓		Rad gauge	
R.50	+/- .030	.500	✓		"	
1.22	+/- .030	1.220	✓		SLIO	
R.50	+/- .030	.500	✓		Rad gauge	
.03 X 45°	+/- .030 X .5°	.030	✓		SLIO	
1.10	+/- .030	1.101	✓			
.550	+/- .010	.549	✓			
1.18	+/- .030	1.180	✓			
.49	+/- .030	.487	✓			
R.13	+/- .030	.125	✓		Rad gauge	
.125	+/- .010	.127	✓		SLIO	
.20	+/- .030	.200	✓		"	
30°	+/- .5°	30°	✓		Protractor	
1.150	+/- .005	1.150	✓		SLIO	
.600	+/- .010	.598	✓		"	
45°	+/- .5°	45°	✓		Protractor	
φ .098	+ .004 / - .001	.097	✓		SLIO	
.17	+/- .030	.170	✓		"	
7/16-20 UNF		7/16-20	✓		Thread gauge	
.63 Deep	+/- .030	.630	✓		SLIO	
7/16-20 UNF	DAS 20	7/16-20	✓	DAS	Thread gauge	

Measured by: 9-89	Checked by: 14 9-89	QC Inspector:
Date: 19-09-03	Date: 19/09/10	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

